

Date: Thursday, 19/10/2006 10:57:10 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STA 155 BRACKET - UNDER REVIEW
Job Number : 29076	
Estimate Number : 11039	
P.O. Number : N/A	Part Number : D28041
This Issue : 19/10/2006 S.O. No. : N/A	Drawing Number : D2804 REV 8
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : UNDER REVIEW
Previous Run : 28181	Material : PRELIMINARY ISSUE
Written By : _____	Due Date : 20/10/2006 Qty: 2 Um: Each
Checked & Approved By : _____	
Comment : Est. A00.11.06 New Issue EC Est. B06.05.30 Blanks on wtjetEC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0500X12000	6061-T6 Bar .50" x 12.0"
Comment: Qty.: 0.7875 f(s)/Unit Total : 1.5750 f(s) 6061-T6 Bar .50" x 12.0" Material: 6061-T6 bar 12.00" x 0.50" Batch: M100046 M 06 10 19		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Template DT8534 Dwg Rev: 3 Prog Rev: 3 2-Deburr if necessary M 06 10 19 (2)		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio FA103 M 06/10/19 2		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE M 06/10/19 2		
5.0	QC8	SECOND CHECK
Comment: SECOND CHECK M 06/10/20 x2		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: DD Date: 06/18/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 19/10/2006 10:57:11 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 155 BRACKET - UNDER REVIEW

Job Number: 29076

Part Number: D28041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Tumble & Deburr

ml 06/10/20 2

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 06/10/20 x2

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

a.m. 06/10/20 (2)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

06/10/20 (2)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/10/20 (2)

Job Completion



u 06/10/20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ENGINEERING CHANGE NOTICE

DART AEROSPACE LTD		Amendment Design Review (ADR) Yes/No:	ECN #: 865
Date: 06-10-19	ADR Date:		
Job No: 00075	Created By: JP	Checked By:	
Product No: D412-630	Approved By:	Approved By:	
Product Name:	(Proj. Manager)	(Management if reqd)	

Documents Affected:

RELEASE D2804 Rev C Preliminary Issue

#	Engineering Actions	Yes	No	Responsible	To happen by:	Complete
1	Required Documents/Drawings Under Review?	✓				
2	Update Blue/Pink Folder/Electronic File		✓			
3	Update DSI Folder/Electronic File		✓			
4	Update D-Part Master Binder		✓			
5	Update Grey Project Binder		✓			
6	Update DEO/DSI Binder		✓			
7	Update Master Document List (MDL)		✓			
8	Update Document Record (DR)		✓			
9	Update Change Record Form		✓			
10	Move Electronic File		✓			
11	Notify TC of Change		✓			
12	Notify FAA of Change		✓			
13	Update QSI 021 (TC/FAA STC)		✓			
14	Update QSI 036 (K-Kits)		✓			
15	Update Accpac Database		✓			
16	Update Access Database		✓			
17	Verification ARC		✓			
18	Update STC Approval List		✓			
19	Update Product Development Summary		✓			
20	Create/Update COSS (Estimate/BOM)	✓		JLM/EC		
21	Create/Update PPP's		✓			
22	Update Paperwork Kits in Production		✓			
23	Update Paperwork Kits in Stock		✓			
24	Red Tag Stock with old CHG #		✓			
25	Rework/Scrap Current Production		✓			
26	Rework/Scrap Kits in Stock?		✓			
27	Update Qpulse/Laminated Dwgs		✓			
28	Create/Update Controlled PDF Files		✓			
29	Create/Update FAI sheets	✓		JLM/EC		
30	Create/Update CNC Programs	✓		JLM/EC		
31	Create/Update Tooling	✓		JLM/EC		
32	MPP required?		✓			
33	Notify Previous Customers	✓		CP		
34	Notify Eurocopter France		✓			
35						
36						

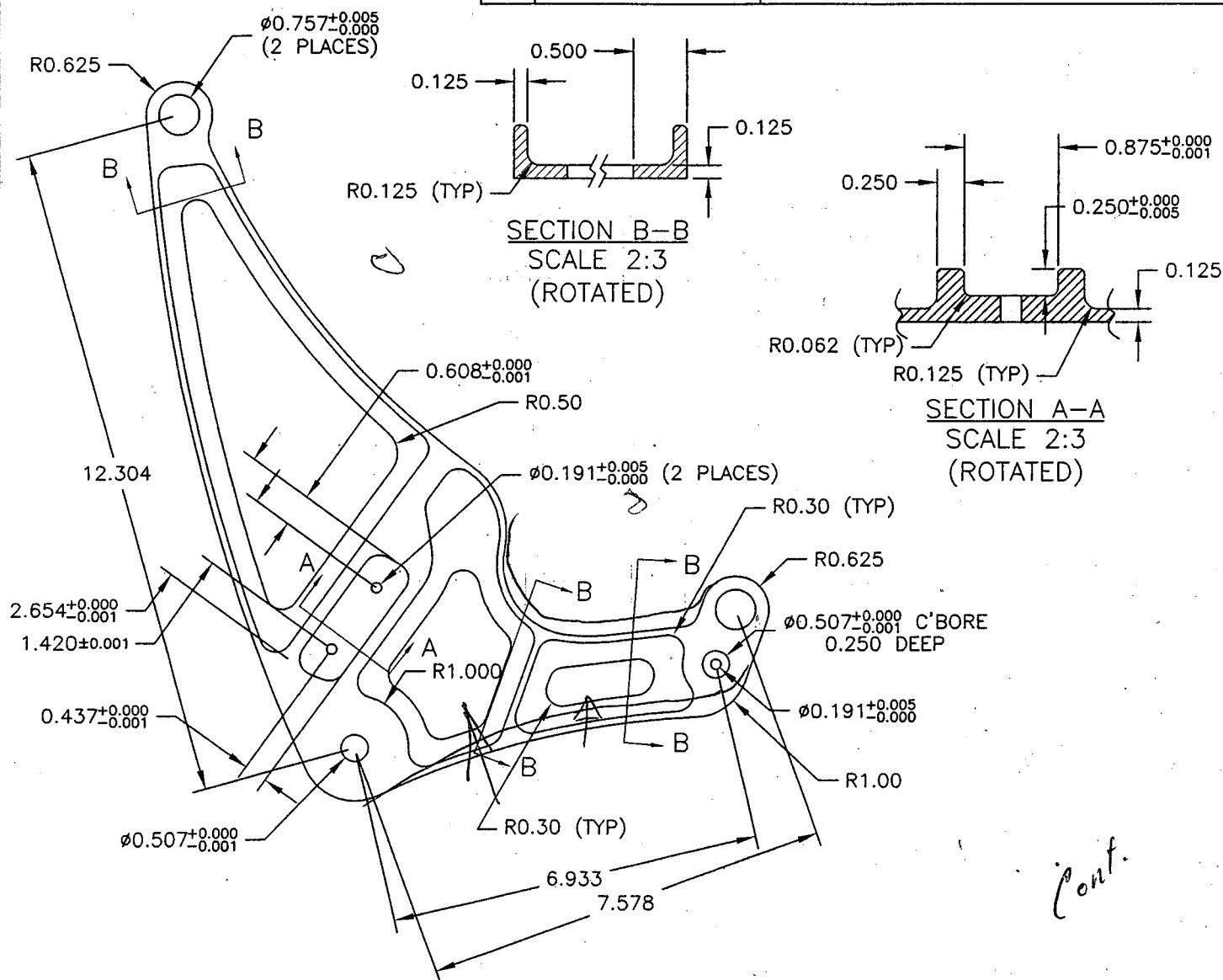
Description / Action:

- WE NEED QTY(1) D2804-041, finished and assembled ASAP
- LL: we need QTY(1) D2803-041 (MADE TO D2803 REV B) and QTY(1) D2804-041 (MADE TO D2804 Rev C Prelim. Issue) READY TO SHIP TO CUSTOMER FRIDAY 20th

ECN Complete: _____ Date: _____



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO. D2804	REV. C SHEET 1 OF 2
DATE	06.10.16			TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07			NEW ISSUE	
B	04.11.22			ADD CUTOUTS & -043/-044	
C	06.10.16			CHANGE GEOM. TO ADD CLEARANCE	



D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)

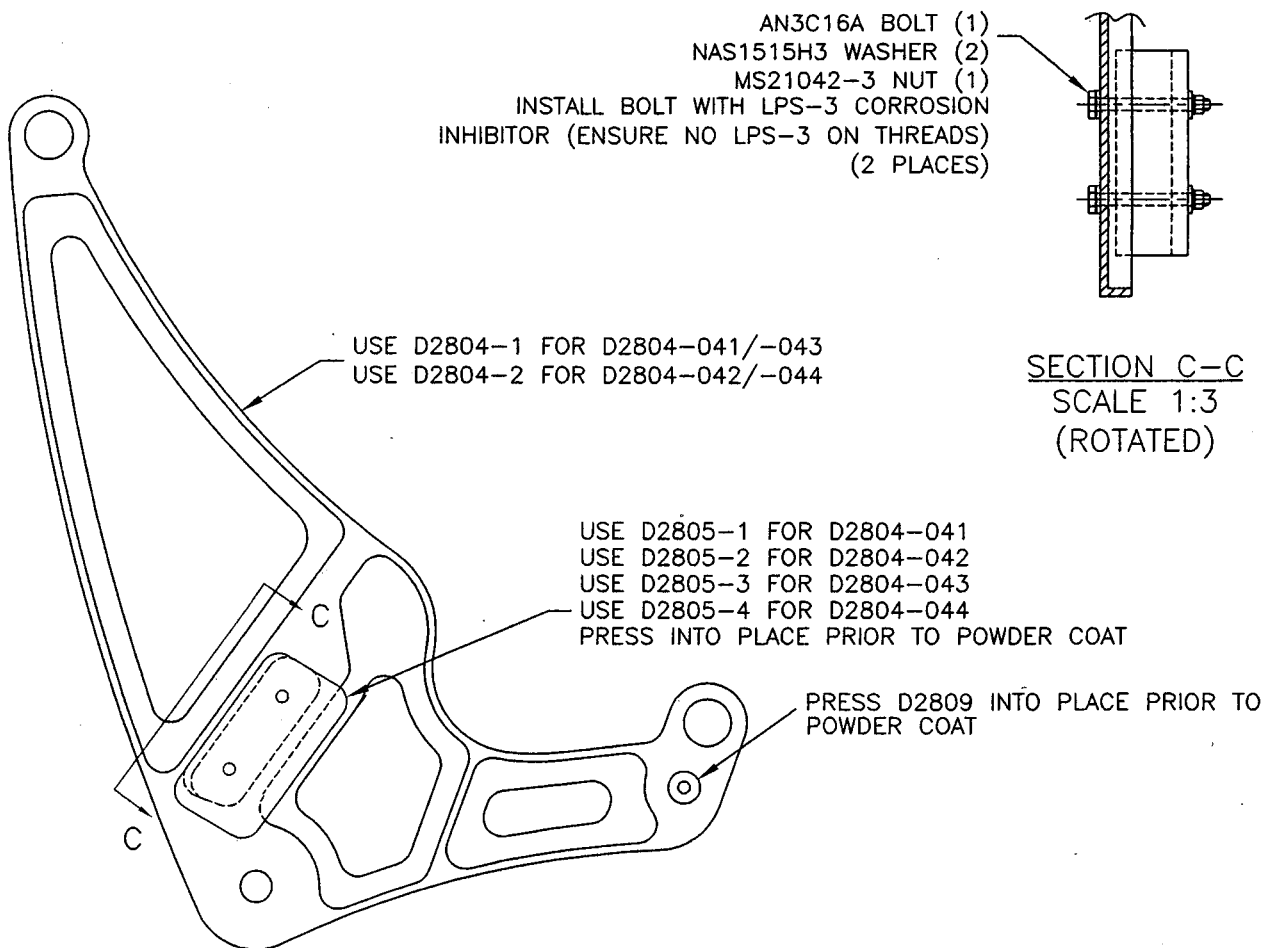
- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN	DRAWN BY	DART AEROSPACE LTD	
CP	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D2804	SHEET 2 OF 2
DATE	TITLE		SCALE
06.10.16	STA 155 BRACKET		1:3



D2804-041/-043 BRACKET ASS'Y (SHOWN).
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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DART AEROSPACE LTD		Work Order: 29076
Description: STA 155 BRACKET		Part Number: D2804-1
Inspection Dwg: D2804 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	±.010	0.124	—			
R0.125	±.010	R0.125	—			
0.500	±.010	0.499	—			
0.125	±.010	0.132	—			
0.250	±.010	0.249	—			
0.875	±.000	0.8745	—			
0.250	±.005	0.246	—			
R0.062	±.010	R0.062	—			
Ø0.757	±.005	Ø0.758	—			
R0.625	±.010	R0.625	—			
12.304	±.010	12.304	—			
1.420	±.001	1.419	—			
0.437	±.001	0.437	—			
Ø0.507	±.001	Ø0.507	—			
6.933	±.010	6.933	—			
7.578	±.010	7.578	—			
Ø0.191	±.005	Ø0.191	—			
0.250	±.010	0.251	—			

Measured by: <i>mil</i>	Audited by: <i>MS</i>	Prototype Approval: <i>CP</i>
Date: 06/10/19	Date: 06/10/19	Date: 06.10.19

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	